

SPLIT-1

Work Order ID 68710 - 1

Wednesday, April 20, 2011 9:09:48 AM

Page 1

Item ID: D3023-1

Accept

Revision ID:

Item Name: Back Panel

Start Date: 4/20/2011

Start Qty: 1.00

Required Date: 4/21/2011

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: A

Prog Rev: A

***graind direction along 28.100" ***

2-Deburr if necessary

B11-4-20

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-4-20

①

Work Order ID 68710

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Page 2

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using
D3017-041 back frame

SD 11/04/25/2 11-5-5 (X1)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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Page 3

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Handwritten: 7 m.p. 11/05/05 (1X)

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

Handwritten: 11:30

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: 12:00

Handwritten: (1X) m.p. 11/05/06

Handwritten: N115128

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten: SAD 11-05-06

Handwritten: (1)

Work Order ID 68710

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Page 4

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location: *G-A*

0.00

Memo

W/068752

0.00

EPH/05/10 @

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*W/15/11 JF**W/15/10*

Picklist Print

Wednesday, April 20, 2011 9:09:45 AM

Page 1

Work Order ID: 68710



Parent Item: D3023-1



Parent Item Name: Back Panel

Start Date: 4/20/2011

Required Date: 4/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M2024T3S.032

Purchased

No

100

sf

55.5000

2.8777

3.029158



B11-4-28

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT22

55.5

111699

0.5

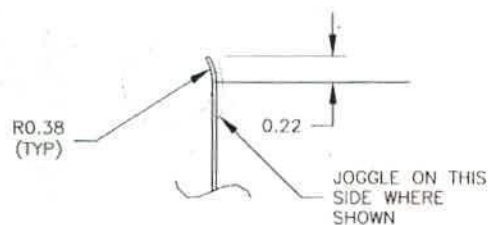
113189

55

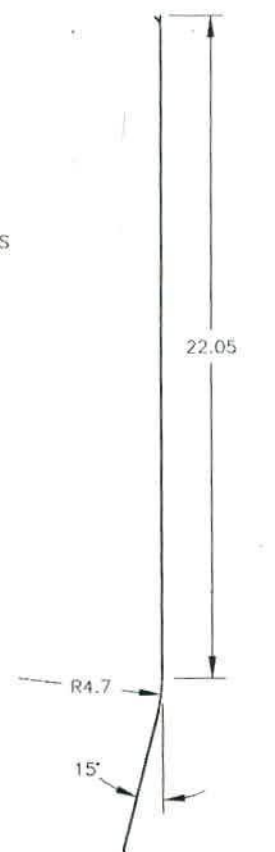
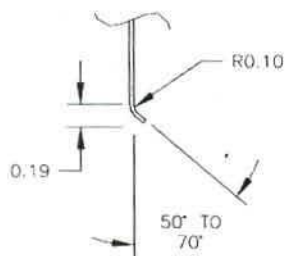
103189

②

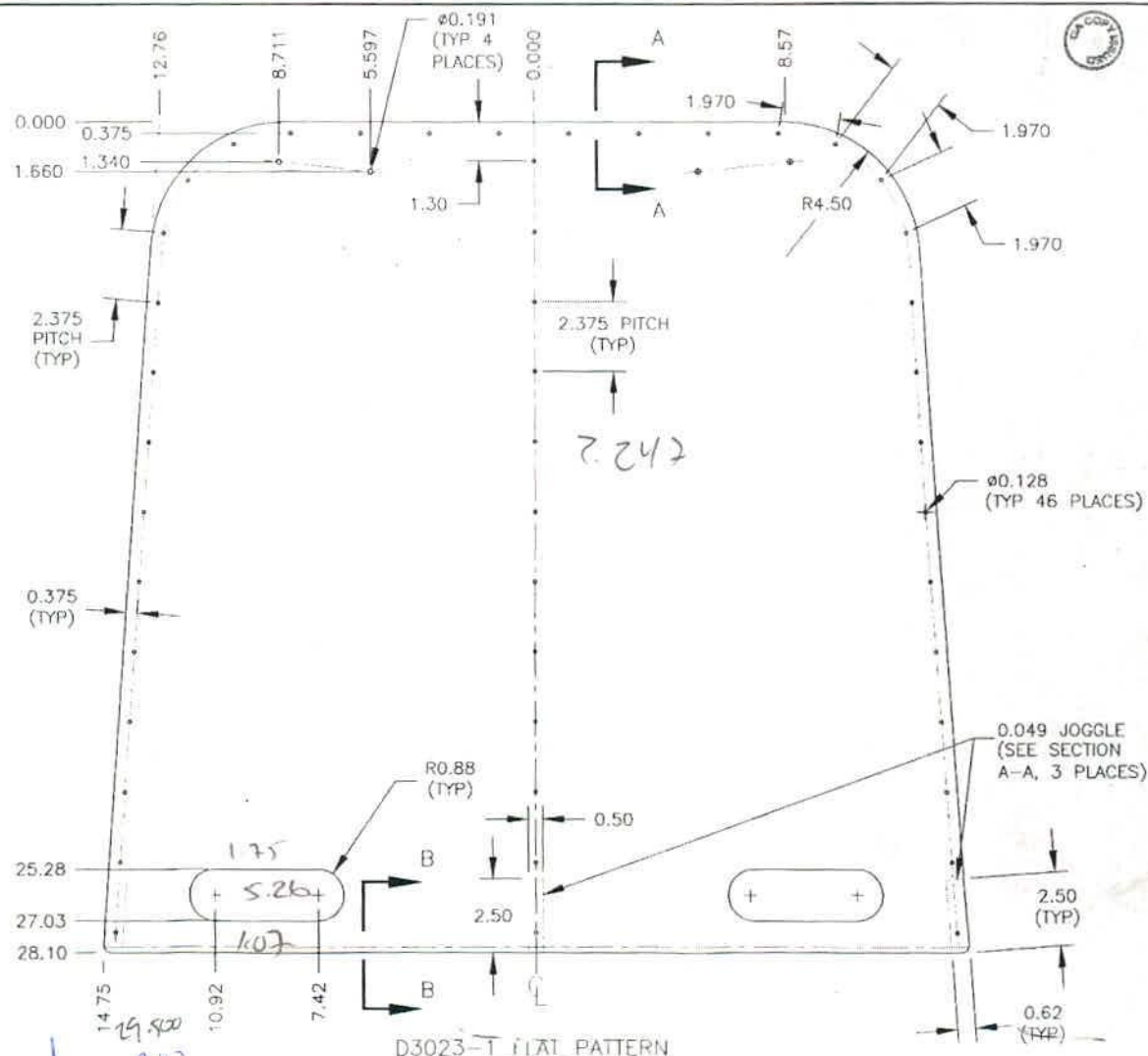
SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

| | | |
|---------|----------|--|
| A | 01.05.18 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D3023 |
| DATE | 01.05.18 | TITLE BACK PANEL |
| | | REV. A SHEET 1 OF 1 SCALE 1:4 |

| | | |
|-------------------------|--------|----------------------|
| DART AEROSPACE LTD | | Work Order: 68710 |
| Description: Back Panel | | Part Number: D3023-1 |
| Inspection Dwg: D3023 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.128 | +0.005/-0.001 | .129 | x | | V #02 | |
| Ø0.191 | +0.005/-0.001 | .194 | b | | V | |
| 1.660 | +/-0.010 | 1.657 | 2 | | V | |
| 0.375 | +/-0.010 | .374 | x | | V | |
| 1.340 | +/-0.010 | 1.336 | 2 | | V | |
| 2.375 | +/-0.010 | 2.374 | 2 | | V | |
| 0.375 | +/-0.010 | .375 | x | | V | |
| 25.28 | +/-0.030 | 25.28 | x | | T H301 | |
| 27.03 | +/-0.030 | 27.03 | 2 | | T | |
| 28.10 | +/-0.030 | 28.10 | 2 | | T | |
| 1.30 | +/-0.030 | 1.294 | 2 | | V | |
| 2.375 | +/-0.010 | 2.378 | 2 | | T | |
| 8.711 | +/-0.010 | 8.711 | x | | T | |
| 5.597 | +/-0.010 | 5.597 | 2 | | T | |
| 8.57 | +/-0.030 | 8.57 | x | | T | |
| 1.970 | +/-0.010 | 1.968 | x | | V | |
| 7.42 | +/-0.030 | 7.42 | x | | T | |
| 10.92 | +/-0.030 | 10.92 | 2 | | T | |
| 14.75 | +/-0.030 | 14.75 | 1 | | T | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|-----------------|----------------|---------------------|-----|
| Measured by: IB | Audited by: S | Prototype Approval: | N/A |
| Date: 11-4-20 | Date: 11/04/21 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.11.27 | New Issue | KJ/EC | AS |